

Work Order ID 150901

646.9603

150901

Page 1

Monday, September 12, 2016 10:25:32 AM

B150901

Item ID: 646.9603

REV N / C Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Cutter Assy Low

Start Date: 9/20/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/23/2016 Req'd Qty: 2.00

2

Customer:

Reference:

DAS
21
9-89

Approvals: Process Plan: _____ Date: SEP 12 2016

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.9600	N/C

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2 OCT 25 2016

DAS
6
9-89

120

0.00

120

Small Fab

Memo

0.09

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 135479
exp. date: 04/18

2x

16/11/01

DAS
36
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.01

Quality Control

2

DAS
38
9-89

NOV 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Accept

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Revision ID:

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: CC-E039 0.00***140***

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER IAW MPP-120

2DAS
6
9-89

NOV 03 2016

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.03

Quality Control

DAS
21
9-89

NOV 07 2016

16-11-03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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OTHER : _____					

Picklist Print

Monday, September 12, 2016 10:25:35 AM

Page 1

Work Order ID: 150901

150901

Parent Item: 646.9603

646 9603

Parent Item Name: Lower Cutter Assy Low

Start Date: 9/20/2016

Required Date: 9/23/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701 *646 9701* Cutter Sub Assembly		Manufactured	No			110	Each	4.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				cck012				4					
					145346			4					
646.9813 *646 9813* Lower Deflector Low		Manufactured	No			110	Each	10.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CCK015				10					
					142493			10					
MS21042L08 *MS21042L 08* Nut		Purchased	No			110	Each	856.0000	3	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				155					
				m134063				55					
				m135274				100					
				ST303				701					
				m135408				125					
				m135466				176					
				m135536				200					
				m135566				200					

DAS
6
9-09

142487 OCT 25 2016

DAS
6
9-09

OCT 25 2016

DAS
6
9-09

OCT 25 2016

6

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Parent Item Name: Lower Cutter Assy Low

150901

646 9603

Start Date: 9/20/2016

Required Date: 9/23/2016

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-19

Purchased

No

110

Each

470.0000

3

6

MS27039-08-19

Screw

DAS

OCT 7 5 2016 6 88

Location

Loc Qty

Loc Code

GA

1

m135046

1

ST277

469

m135408

69

m135536

100

m135566

300

6

NAS1149FN832P

Purchased

No

110

Each

3,153.000

6

12

NAS1149FN832P

Washer

DAS

OCT 2 5 2016 8 88

Location

Loc Qty

Loc Code

GA

1553

M133316

16

M133769

89

M135058

1448

ST263

1600

M135603

1600

12

DQA: _____ Date: _____



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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02743				SHEET 1 OF 1	
	DWG NO. 646.9600		REV: N/C	PREPARED BY S. HUFF	DATE: 01/07/10	EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: CUTTER ASSY					
	APPROVED BY:	ENGR <i>P. Brans</i>	MFG <i>Amel G...</i>	QC <i>W. L...</i>	EFF: NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED SCREW LENGTH.					

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 150901 ML5
1609-12

3	R	601.3157	3	3	3	SCREW	MS27039-0818
			.9603	.9602	.9601		
F/N	TC	PART NUMBER	QTY		DESCRIPTION		MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
☐ MDL ☐ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM						☐ MAJOR ☒ MINOR	☐ YES ☒ NO

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION PER		11/11
2	WITH RELEASE	04/30/07	P. BRAY

